
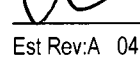


Date: Wednesday, 30/01/2008 7:52:04 AM
 User: Linda Lacelle



Process Sheet



Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FLOOR PROTECTOR FWD RH
Job Number :	37109		
Estimate Number :	11234		
P.O. Number :		Part Number :	D32812
This Issue :	30/01/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3281 REV. B
First Issue :	11	Project Number :	N/A
Previous Run :	35247	Drawing Revision :	BC
	Type :	Material :	
	THERMOFORMING	Due Date :	06/02/2008
Written By :		Qty:	2 Um: Each
Checked & Approved By :			
Comment :	Est Rev A 04.07.01 New issue KJ/JLM Est Rev B 07.08.07 Thermoform in house DL		



Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	F6006 701	lexan black
		
Comment: Qty.: 4.0000 sf(s)/Unit Total : 8.0000 sf(s) lexan black M 106957		

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
		
Comment: HAND FINISHING THERMOFORMING <div style="text-align: right;">3B 08/01/30</div>		
1) Cut Blanks		

3.0	THERMOFORMING	THERMOFORMING MACHINE
		
Comment: THERMOFORMING MACHINE Thermoform as per Dwg. D32811 and Folio FTA 008		

Dwg. Rev. C
 Folio Rev. B

3B 08/01/30. (X2)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <div style="text-align: right;">3B 08/01/30</div>		

5.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
		
Comment: HAND FINISHING THERMOFORMING <div style="text-align: right;">x2 H. 08.01.30</div>		
1) Trim to Finished Dimensions		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 30/01/2008 7:52:04 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services.

Drawing Name: FLOOR PROTECTOR FWD RH

Job Number: 37109

Part Number: D32812

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check dimensions to ensure conformity to drawing tolerances.

x2

DLV. 08.01.30

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2/6/6

DLV 08/01/30 (E2)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

2/6/6

8/1/30

50 (2x)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(2)
2080/30

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

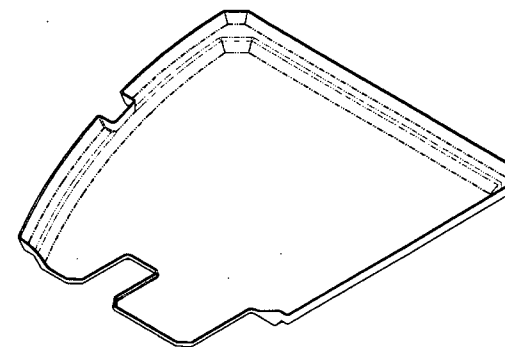
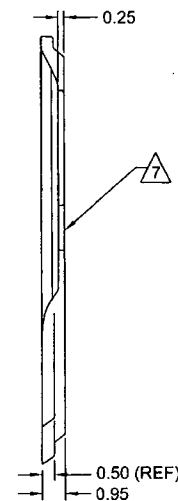
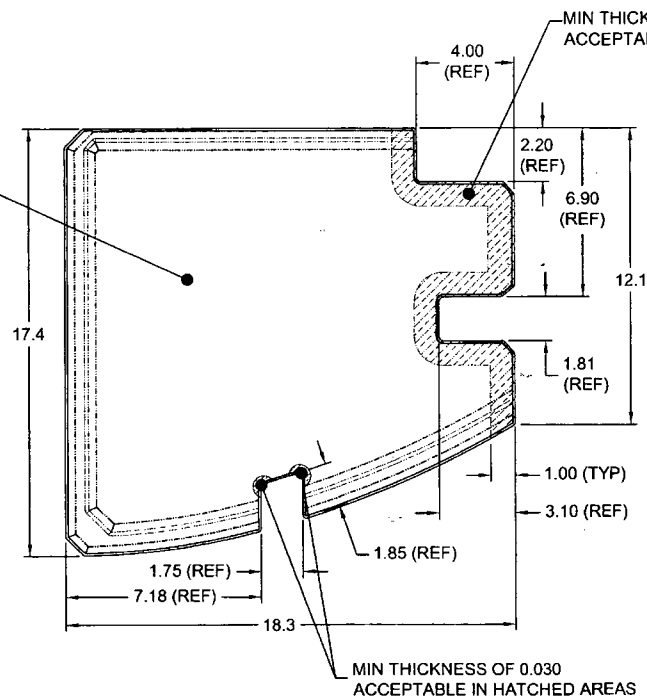
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

TEXTURED SURFACE
ON THIS SIDE



37109

RELEASED
07-11-06

D3281-2 FLOOR PROTECTOR

D3281-2 NOTES:

- 1) THERMOFORM WITH MOLD D3281-2T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.080" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.125" THICK
(REF DART SPEC MLEXS. 125-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-2" ON SMOOTH SIDE OF PART USING WHITE PAINT MARKER
- 8) WEIGHT: 1 lb

DESIGN	90	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AT	DRAWING NO.	REV. C
MFG. APPR.	SL	D3281	SHEET 2 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	FLOOR PROTECTOR	NTS
DATE	07.10.09	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

DART AEROSPACE LTD	WORK ORDER: 37109
Description: R44 Floor Protector FWD RH	Part Number: D3281-2
Inspection Dwg: D3281 Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

(Step 4) Thermoforming
Visual Inspection Sign-off

Description	Initials
	BB
Inside Radii less than 3/16" go/no go	BB
Acceptable shape definition	BB
Acceptable texture retention	BB
Free of visual flaws (bumps, cracks, voids, etc.)	BB

(Step 6) Trimming FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing D3281 Rev. C and record below

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.3	.1	18.3	✓			
17.4	.1	17.375	✓			
12.1	.1	12.1	✓			
0.95	.03	0.95	✓			
0.25	.03	0.258	✓			

Measured by: <u>DL</u>	Audited by: <u>DL</u>	Prototype Approval: <u>✓</u>
Date: <u>08.01.30</u>	Date: <u>08/01/31</u>	Date: <u>1/12</u>

Rev	Date	Change	Revised by	Approved
		New Issue		